

Date: Tuesday, 4/18/2006 9:58:37 AM  
 User: Kim Johnston

## Process Sheet

SPS split  
06/06/12

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING
Job Number	: 26646		
Estimate Number	: 10336		
P.O. Number	: N/A	Part Number	: D2807
This Issue	: 4/18/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2807 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25247	Drawing Revision	: C
Written By	<u>See JLM</u> Comment below		Material : N/A
Checked & Approved By	<u>JLM</u> 06.04.18		Due Date : 5/5/2006
Comment	: Est: D 05.06.21 Removed painting; Changed supplier KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: 1035 Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required	
2.0	SXF6S6050080S6L115N	GAS SPRING	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) SUPPORT PROP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	
5.0	D28073	Lug	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s) Pick: 2 D2807-3 Lug Batch: B26625 (20) B27 #52 (4)	

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 26646

Part Number: D2807

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1



SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.

*SAO 06/06/12 12*

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 06/06/12 12*

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*SB 06/06/12 12*

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

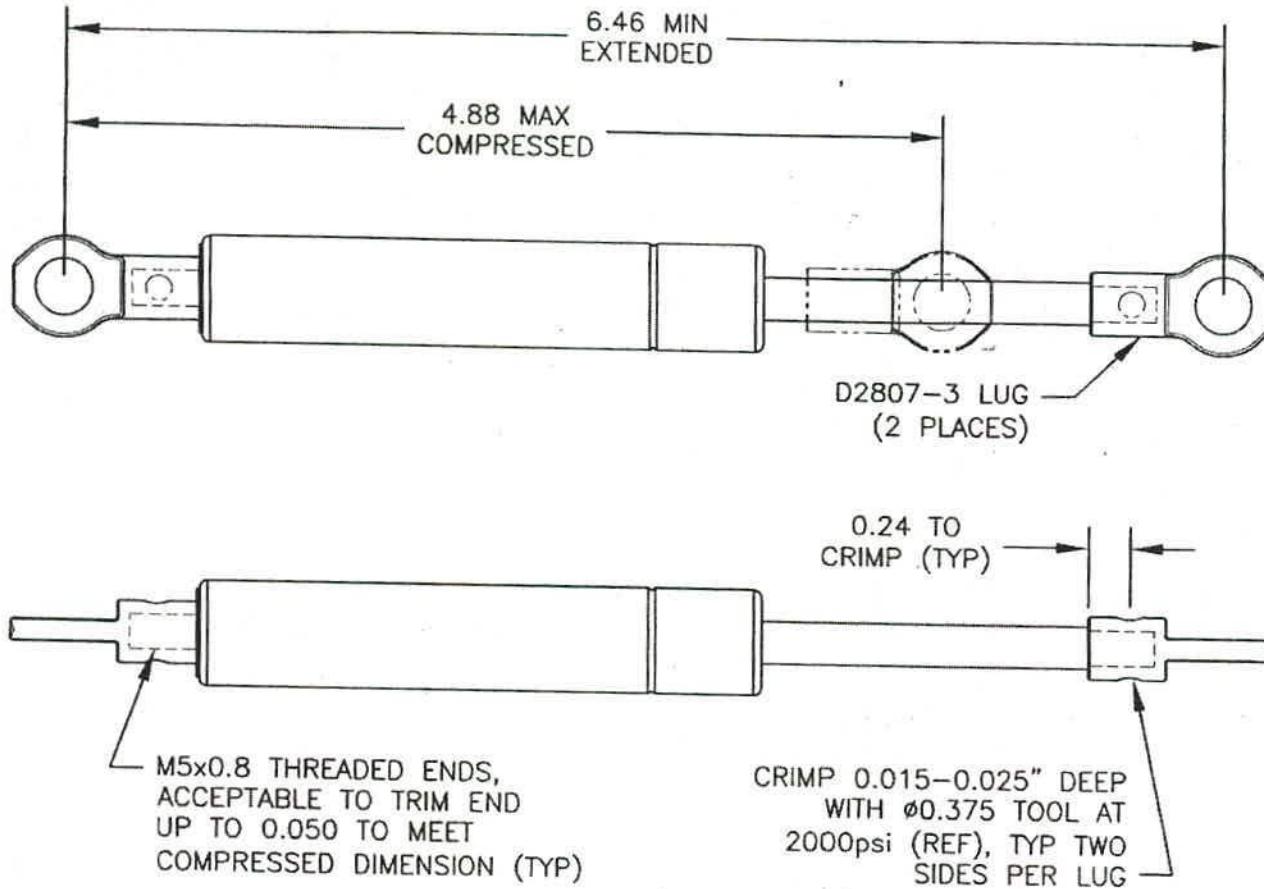
Inspection Level 21

*DP 06/06/13 12*

Job Completion



*U 06/06/13*

**DART****RELEASED**  
05.06.16**D2807 GAS SPRING**

- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS
- 2) SHORT COPY  
SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- NO. 26646
- RETB  
ENGINEERING  
INCONTRO  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WITHOUT ORDER

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <u>W</u>	APPROVED <u>W</u>	DRAWING NO. D2807
DATE 05.05.25	TITLE GAS SPRING	REV. C SHEET 1 OF 2
A	00.11.03	SCALE 1:1
B	05.03.16	NEW ISSUE
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG

**INVOICE TO**

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ONTARIO  
K6A 1K7  
CANADA

DART AEROSPACE LTD  
SHIP WITH AE: 57561 VIA  
FEDEX P-1 OVERNIGHT SVCE  
ACCOUNT NO: 15179324-0

URUGUAY

A/C No.	AREA
20111	46

**CUSTOMER REF. NO.**

V.A.T. REGISTRATION No. GB 738 8577 71

WORDER  
NUMBER

Cam 00

**Arvin Motion Control Limited**  
Main Tel: +44 (0)116 274 3600  
Sales Tel: +44 (0)116 274 3622  
Accounts Tel: +44 (0)116 274 3

15 New Star Road, Leicester, LE4 9JD, UK  
Main Fax: +44 (0)116 274 3620  
E-mail - [info.camloc@arvinmeritor.com](mailto:info.camloc@arvinmeritor.com)  
Website: [www.camloc.com](http://www.camloc.com)

FED EX  
8490 2198 6376

**YOUR ORDER WAS PACKED BY** 

Certified that the whole of the supplies detailed herein have been inspected and tested and unless otherwise stated conform in all respects with the contract/purchase order requirements.

SIGNED